Work Order		<b>1</b>		*919	n6*						Page 1
Revision ID: Item Name: D	0/18/12 St	art Qty: 1.00	*1*	Accept	*N900		100	<b>)*</b> s	Setup Star	1 71	S1* S2*
Required Date: 1	1/02/12 Re	eq'd Qty: 1.00	*1*		Customer:	:					
Reference:								г	Run Stai	·f .s.a.s	- 4 .1.
Approvals: I	Process Plan:	MLJ	Date: 12-10-2	2Tooling:	Ε	Date:		r		1/1	R1*
(	QC:		Date:	<b>SPC (Y/N):</b>		Date:			Sto	۳ <b>*</b> N	R2*
Sequence ID/ Work Center ID		peration scription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	n Nbr		The state of the s							
IIN D412-698	Rev E										
*100* DC Document Control	DO	CUMENT CONTROL  Memo  Photocopy bli		0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00	10001 1B			H	160 i	MUT	12-10-2
Document Control		Thotocopy on	actine and create (acc)s p								
*110 *110* Packaging Packaging	Pic	k Kit <b>Memo</b>		0.00						<b>.</b>	12/10/24/
120 *120* QC Quality Control	QC	4- 100% Inspect kits fo	or completeness	0.00	2/co/25						·· · ·

NCR:	Yes /	No			WORK ORDER NON-	COI	NFORN	MANCE / UPI	DATE			
	,									QA Closed:	Date:	
Work Ord	or:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIG	C1.				Rework	٦		Skid-tube	Crosstube	7	Water Jet	Engineering
Part f	No.				Scrap	1	l	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	1	noforming	Finishing	4	e/Packaging	Other
NCR I	No			<del> </del>	Work Order Update	]		Large Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	T	Initial	Act	ion	Sign &		
Cause	Da	te Ster	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
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Supplier						ŀ						
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Unapproved		<u> </u>		ļ. <u> </u>								
						AUL	T CATE	GORY				
Landi	ng Gear				General	_	1			7	<b>-</b>	<b>-</b>
	Bend	•		<u> </u>	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
	Cent	e Not Cond	entric to	o/s	BOM/Route	_	Hardwa			Over/Under	·	Temperature/Cure
	Cracl				Broken/Damaged	$\perp$	4	ion Incomplete		Part Incorre		Weld
•		ed/Crimpe	ed.	L	Burrs	L	1	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	<u></u>	Mainte		. }	Part Moved		
		Treat		L	Countersink	_	Mislabe		<u> </u>	Positioned V		<b></b>
		ction Strip	in Tube		Cut Too Short	1_	Misread	1		Power Loss/	Surge	Other
	Rippl	es in Bend		<u></u>	Drill Holes	L	Offset					
	Torqu	ie Waves ir	n Extrusio	n	Drawing	1	Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Work Ord		906		*919	306*							Page 2
Item ID: Revision ID: Item Name:	D412-698-01  Door Support	5		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	- 1 1	S1* S2*
Start Date: Required Date: Reference:	10/18/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:		n:	Date:			ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II		Operation Description	**************************************	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	-	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Location:	pack for shipping as p	0.00 0.00 er PPP D412-698-015					a		12	110/250
<sup>140</sup> <b>*14</b> ∩*		PPP Rev:	Work Order Release	0.00					,	121	10/0	294
QC Quality Control		Memo		0.00						·	MLS	7998

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NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE				7
											QA Closed	: Dat	:e:	•
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
Work Ord	٠					Rework	7		Skid-tube	Crosstube		Water Jet		Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pro	od. Eng. Coor.		Quality
	•					Use-as-is	1	1	noforming	Finishing	4	re/Packaging		Other
NCR	No.					Work Order Update	1		Large Fab	Composite		Supplier		
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Root						ption of work order update	1	Initial		ction	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	า	QC Inspector
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Equip/Tooling	Ш													
Operator	Щ												ļ	
Material	Ш		]											
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Landi					_	General	_	7			7	1	_	1 .
	-	Bending			ļ	Bend	L	Grain			Ovalized		<u> </u>	Pressure/Forced
	ш	Centre No	t Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			Over/Unde		<u> </u>	Temperature/Cure
	Ш	Cracks				Broken/Damaged	L	-	on Incomplete		Part Incorr		<u> </u>	Weld
	▭	Crushed/(	Crimped			Burrs		-1	ions Incomplete/	'Unclear	Part Lost/N	•		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Move			
	Ш	Heat Trea	t			Countersink		Mislabe	led		Positioned	_		1
		Inspection	Strip in	Tube		Cut Too Short		Misreac	i		Power Loss	/Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

## Picklist Print

October-19-12 2:22:04 PM

Work Order ID:

91906

Parent Item:

D412-698-015

Parent Item Name:

Door Support

**Start Date:** 10/18/12

Required Date: 11/02/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacen	nent	Mfg/	Bir	Pri	mary
	IPP Rev:D	change	to rev D	ECN 1104	08-01-2	8 DD
Comments:	IPP Rev:C	Remo	oved Manu	facturing 0	6-01-25	JLM

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	AN960JD101 Washer	NAS1149D0332J	Purchased	No			110	Each	0.0000	122	973	je	3 ~	5m6>
	D3200-1 Door PostiBlock		Manufactured	No			110	Each	33.0000	22.	2	- yo_		7.00
3					<b>Location</b>		Loc Qty	<u>L</u> c	oc Code				751	00
					ST033		33							·
					821:	54	21			82	154			
					908	73	12							
	<b>D3200-3</b> Door Wedge		Manufactured	No			110	Each	39.0000	2 * Aller Aller (1) of the property of the pro	2	1B	TO THE RESIDENCE OF THE PARTY O	
	J				Location		Loc Oty	Lo	oc Code				ゴカ	26
					ST033		39						_	
					821:	55	19			83	2153			
					908:		20							
	D3201-1 Doubler		Manufactured	No			110	Each	17.0000	2	2	26	3	
>					Location		Loc Oty	Lo	oc Code			•		
					ST033		17					$\leq$	M/	
					6896	68	1					٠,	. 10	
					8684	<b>4</b> 3	6			***************************************				
					905	52	10			90	552			
	<b>D3201-3</b> Doubler		Manufactured	No			110	Each	22.0000		1 •	JB		2/10/2
-					Location		Loc Qty	Lo	oc Code			~		. ,
					ST033		22						0	
					7166	51	10			71	661	5)	nA	
					908:		12				~ * /		-	

NCR: Y	es / No				WORK ORDER NON-C	CON	FORM	MANCE / UPI	DATE			
								<u>-</u>		QA Closed:	Date:	<b>46</b> ·
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root		<u> </u>		Descri	ption of work order update	In	itial	Act	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chie	ef Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												, .
quip/Tooling												·
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Jnapproved		L	<u></u> 1			<u> </u>	CATE	CORV				
Landin	ıg Gear			3	General	HOLI	CATE	JONT				
Landin	Bending				Bend	$\Box$	Grain			Ovalized		Pressure/Forced
}	Centre No	nt Concer	atric to C	)/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
ŀ	Cracks	or concer		" —	Broken/Damaged	-		on Incomplete		Part Incorre	<del></del>	Weld
ľ	Crushed/0	Crimped			Burrs		•	ions Incomplete/l	Jnclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
ŀ	Cuffs	J			Contamination	_		nance		Part Moved		
.	Heat Trea	t			Countersink		∕lislabe	led		Positioned V	Vrong	
ŀ	Inspection		Tube		Cut Too Short	-	Misreac			Power Loss/		Other
ľ	Ripples in				Drill Holes	-	Offset			•		
ľ	Torque W		xtrusion		Drawing	П	Out of C	Calibration				
ľ	Turning Se				Finish		Out of S	Sequence				

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

	October-19-12 2:2	2:05 PM										r age 2
	Work Order ID:	91906										
,	Parent Item:	D412-698-015							Start	Date: 10/18/12		Required Date: 11/02/12
	Parent Item Name:	Door Support							Star	t Qty: 1.00		Required Qty: 1.00
(	D3201-4 Doubler		Manufactured	No			110	Each	23.0000	The second secon	1	V 2B
					Location	<u>1</u>	Loc Qty		Loc Code			SNA
					ST033		23					
						82357	4			8235	7	
						83507	19					
K	MS210421.3 Nut		Purchased	No			110	Each	3,340.0000	IP.	12	78
8					Location	<u>1</u>	Loc Oty		Loc Code			•
					316		651					
						122452	651					
					ST300		338					SmO
						117885	32					J (
						119017	168					
						119075	138					
					ST314		1831					
						123265	1831			12326	9	
					ST317		520					
						122141	520			_		
	MS24693-S2777 Screw		Purchased	No			110	Each	51.0000	12	12	20 12/16/24
					Location	<u>1</u>	Loc Qty		Loc Code			•
					304		50					
						122441	50			1224	4]	
					ST288		1					SMA
						117591	1					JHIL

NCR: Y	'es / No				WORK ORDER NON-	CON	<b>VFORI</b>	MANCE / UPE	DATE			•
	,							•		QA Closed:	Date:	ÿ
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		Ī		Descri	tion of work order update	П	nitial	Act	ion	Sign &	· · · · · · · · · · · · · · · · · · ·	
Cause	Date	Step	Qty		or Non-conformance	ŧ	ief Eng		iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material [			<u> </u>									
Setup												
Other												
Process												
Supplier											2	
Training												
Unapproved						<u>.</u>				<u></u>		
						AUL	T CATE	GORY				
Landir T	ig Gear				General		. ·			1	[	Pressure/Forced
}	Bending	_			Bend	-	Grain		<u> </u>	Ovalized Over/Under	A-1	Temperature/Cure
}	Centre No	ot Concer	ntric to C	<sup>D/S</sup>  -	BOM/Route	-	Hardwa		-	Part Incorre	<u> </u>	Weld
}	Cracks	o : .			Broken/Damaged	$\vdash$	-	ion Incomplete	la aloga	Part Lost/Mi	<b>├</b>	Wrong Stock Pulled
	Crushed/0	Crimped.			Burrs	-	Mainte	ions Incomplete/L	nciear	Part Moved	2211.B	I wrong stock runed
}	Cuffs			-	Contamination Countersink	-	Mislabe		ļ	Positioned V	Vrong	
}	Heat Trea		Tubo		Cut Too Short	_	Misread			Power Loss/		Other
-	Ripples in	-	rube	<u> </u>	Drill Holes	$\vdash$	Offset		<u>L.</u> .	1. 0.4.6. 5033/		10000
	Torque W		vtrusion	$\vdash$	Drawing	-		Calibration				
}	Turning S		ACI USIOII		Finish			Sequence				
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Outside Dimensions

DQA: Date:

Wave/Twist in Tube

Folio

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## 7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty <b>≤</b> 015 <b>∗</b>	Qty -023	Part Number	Description
Х		D412-698-015	DOOR SUPPORT KIT
	Х	D412-698-023	AUTOMATIC DOOR OPENER KIT
-2-		-D3200-4	-DOOR-POST-BLOCK
2		D3200-3	-DGGR-WEDGE
2		-D3201-1	DOUBLER
		D3201-3	ANGLE
-		■D3201=4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
			NA CUED
12		AN960JD10L-	*WASHER
	2	AN960JD516L	WASHER
-12	-	MS21042L3	*NUT*(OR,MS2,1042-3)
12		MS24693-S27.7	SCREW